

**Work Order ID 103324**

Thursday, June 20, 2013 4:02:16 PM

*Push Slip Tomorrow*  
**\*103324\*****ASAP**

Page 1

Item ID: D4434-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Fwd inboard Bracket Assembly

Start Date: 6/20/2013 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 6/24/2013 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *13-6-20*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4434

B

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-1 as per Dwg

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

*4* *φ* *13.06.21*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*4* *φ* *13.06.21*

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Item ID: D4434-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Stop **\*NS2\***

Start Date: 6/20/2013 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 6/24/2013 Req'd Qty: 4.00

**\*4\***

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				4			
		13621							
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo 1-C'sink as per dwg.	0.00 0.00				4			 13/06/24
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				4			
		13624							



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Item ID: D4434-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Fwd inboard Bracket Assembly  
Start Date: 6/20/2013 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 6/24/2013 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

185	QC5- Inspect part completeness to step on W/O	0.00				4			
<b>*185*</b>									
QC	Memo	0.00							
Quality Control									

190	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
<b>*190*</b>									
Powdercoat	Memo	0.00							
Powder Coating	*** MASK NUT PLATE HOLES PER DWG ***								

START TIME: 8:30  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 9:00

200	QC3- Inspect Part Finish	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

4X4 m/f 13/06/26

4x4 m/f 13/06/26

M123480

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**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 6/20/2013      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 6/24/2013      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.**  
**Stamp**

202

0.00

**\*202\***

0.00

### Small Fab

## Memo

## Small Fab

Install rubber seals and grommets.

3M 1300 batch: M124297

0.00

205

\*205\*

0.00

QC.

## Memo

## Quality Control

Identify as per dwg & Stock Location: 10A

0.00

210

**\*210\***

0.00

### Packaging

## Packaging

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Item ID: D4434-043      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Fwd inboard Bracket Assembly  
Start Date: 6/20/2013      Start Qty: 4.00      **\*4\***      Cust Item ID:  
Required Date: 6/24/2013      Req'd Qty: 4.00      **\*4\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21 - Final Inspection - Work Order Release	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									

13/6/27 *[Signature]*

U13-d6.26

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**Required Qty: 4.00**

**Comments:** IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA5  
EC verified by:JLM IPP RevC 12.01.24 per REV.A DD verified by:EC  
IPP RevD 12.03.05 per REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	653.6856	2.5	10.526316			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		653.6856							
				121099		273.7156							
				<u>123874</u>		379.97							
D4434-9 Bracket		Manufactured	No			180	Each	6.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
				94753		1							
				<u>98635</u>		5							
D4435-041 Bracket Assembly		Manufactured	No			180	Each	28.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST109		28							
				95741		1							
				96931		27							
D4441-1 Rubber Seal Cut qty 1 to 1.7"		Manufactured	No			202	f	385.7046	0.142	0.568			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST412		385.7046							
				74760		6.119							
				79385		0.0476							
				80763		35.656							
				86185		343.882							

# Picklist Print

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Work Order ID: 103324

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 6/20/2013

Required Date: 6/24/2013

Start Qty: 4.00

Required Qty: 4.00

D4441-1  
Rubber Seal  
Cut qty 1 to 2.5"

Manufactured No

f 385.7046

0.832

FF 13-06-26

Location	Loc Qty	Loc Code
ST412	385.7046	
74760	6.119	
79385	0.0476	
80763	35.656	
86185	343.882	

0.832

7.5

FF 13-06-26

D4441-1  
Rubber Seal  
Cut qty 1 to 22.5"

Manufactured No

f 385.7046

Location	Loc Qty	Loc Code
ST412	385.7046	
74760	6.119	
79385	0.0476	
80763	35.656	
86185	343.882	

7.5

4

FF 13-06-26

D4440-1  
Grommet

Manufactured No

202 Each 18.0000

1

4

Location	Loc Qty	Loc Code
GA	17	
80645	1	
91714	16	
ST139F	1	
79372	1	

2

AN525-832R6  
Screw

Purchased No

180 Each 271.0000

3

12

FF 13-06-25

Location	Loc Qty	Loc Code
ST344	271	
125303	271	

12

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Shop Packet Print

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# Picklist Print

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Work Order ID: 103324

Parent Item: D4434-043

Start Date: 6/20/2013

Required Date: 6/24/2013

Parent Item Name: Fwd inboard Bracket Assembly

Start Qty: 4.00

Required Qty: 4.00

MS20426AD3-3 Purchased  
Rivet

No

180 Each 18,153.000 12 48

FF 13-06-25

Location

Loc Qty

Loc Code

Mezz 123352

18153

1173

8873

13276

9280

48

MS20426AD3-3 Purchased  
RIVET

No

180 Each 6,896.0000 2 8

FF 13-06-25

Location

Loc Qty

Loc Code

ST316

699

119109

282

19099

417

ST333

6197

121011

29

122814

120

123352

6048

8

MS20470AD4-3 Purchased  
Rivet - Universal Head

No

180 Each 6,174.0000 5 20

FF 13-06-25

Location

Loc Qty

Loc Code

GA

1818

1642

302

2193

1516

ST335

4356

2193

4356

20

MS21075L08 Purchased  
ANCHOR NUT

No

180 Each 62.0000 7 28

FF 13-06-25

Location

Loc Qty

Loc Code

GA 126084

7

120560

7

ST318

55

103053

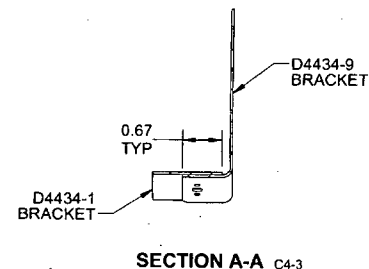
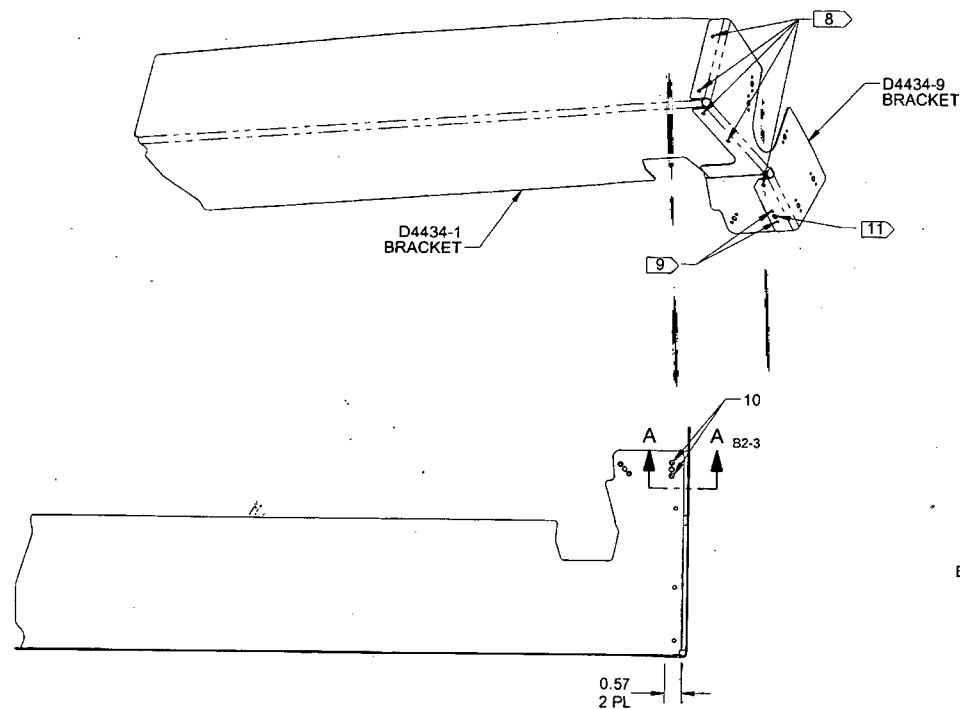
55

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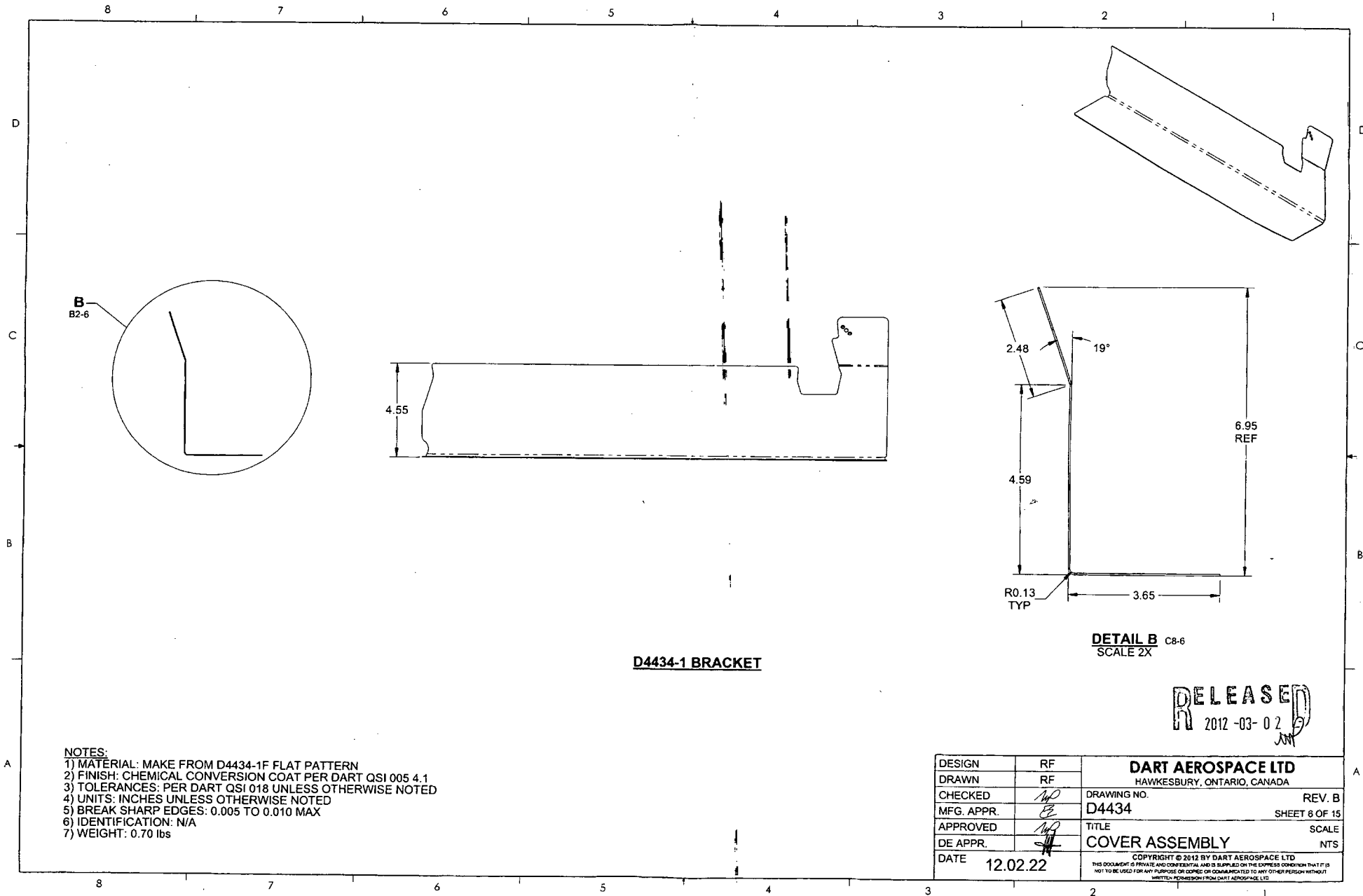
SECTION A-A C4-3

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs
  - 8) TRANSFER  $\varnothing 0.129$  HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
  - 9) TRANSFER  $\varnothing 0.098$  HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
  - 10) CSK  $\varnothing 0.179 \times 100^\circ$  ON THIS SIDE 2 PLACES
  - 11) TRANSFER  $\varnothing 0.177$  HOLE THRU FROM D4434-9 TO D4434-1

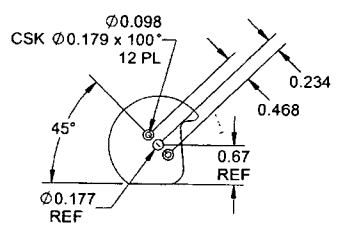
**D4434-043 FWD INBOARD BRACKET ASSEMBLY**  
AUXILIARY VIEW

RELEASED  
2012-05-03

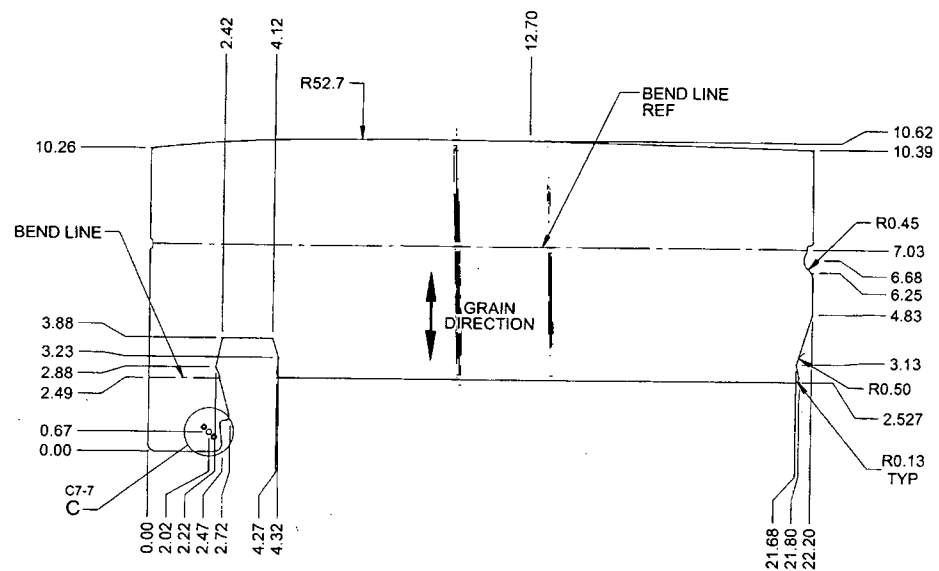
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	EE	<b>D4434</b>	SHEET 3 OF 15
APPROVED	MD	TITLE	SCALE
DE APPR.	#	<b>COVER ASSEMBLY</b>	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



**DETAIL C** B6-7  
SCALE 2X



**D4434-1F FLAT PATTERN**

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

**RELEASED**  
2012-03-02  
JW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D4434</b>	REV. B
MFG. APPR.	RF	SHEET 7 OF 15	
APPROVED	RF	TITLE <b>COVER ASSEMBLY</b>	SCALE NTS
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8 7 6 5 4 3 2 1

